

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015184**Date Inspected:** 17-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

West of Bay 19-

Caltrans QA Inspector verified OBG Segment 10CW X37 plates to internal horizontal stiffeners attaching deck panel I ribs to the edge and deck plate and the following work in progress: Alignment appeared to be in conformance with the applicable contract documents.

Caltrans QA verified that the angle iron stiffener attached to the bottom panel stiffener flanges had been repaired at panel point 92.5 adjacent to the longitudinal diaphragm. A portion of the angle iron was removed to install a longer section to comply with contract documents (30mm from LD). ZPMC personnel have made this weld a Complete joint penetration weld.

West of Bay 14-

Caltrans QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 11DE FL3 floor beam to side panel weld, SEG067A-005. ZPMC welder was identified as 054013. ZPMC QC was identified as Tang Ya Jun. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-TC-U4b-FCM-1.

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Flux Cored Arc Welding (FCAW) of OBG Segment 11DW drip plate weld, OBW11F. ZPMC welder was identified as 201583. ZPMC QC was identified as Li Ping. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
